

Date: Tuesday, 09/12/2008 9:39:00 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HAT BIN (407)	
Job Number	: 43953		Part Number	: D38351	
Estimate Number	: 13676		Drawing Number	: D3835-1	
P.O. Number	:		Project Number	: IN0002	
This Issue	: 09/12/2008 S.O. No. :		Drawing Revision	: PROTOTYPE	
Prsht Rev.	: NC		Material	: MKYD6185S080P362015	
First Issue	: / / Type : THERMOFORMING		Due Date	: 16/12/2008 Qty: 1 Um: Each	
Previous Run	:				
Written By	:				
Checked & Approved By	: JUL 08.12.09				
Comment	: Est. Rev. A. 08.12.03 New Issue DL				

Additional Product

PROTOTYPE
08.12.09 PL

UPDATED PL 08.12.22

Seq. #:	Machine Or Operation:	Description:	
1.0	MKYD6185S080P362015	6185 KYDEX .080"	MATERIAL CERTIFICATION REQ'D UPON DELIVERY
		Comment: Qty.: 11.9438 sf(s)/Unit Total : 11.9438 sf(s) 6185 Kydex .080"	11.108703 08.12.10
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	
	1) Machine set up		PL 08.12.10
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	(X1)
	1) Cut sheet to required blank size		PL 08.12.10
4.0	THERMOFORMING	THERMOFORMING MACHINE	
		Comment: THERMOFORMING MACHINE	(X1)
		Thermoform as per Dwg. D3835-1 and folio (FTA 407 Hatbin)	
	Dwg. Rev. <u>PROTOTYPE</u>	Folio Rev. <u>A</u>	PL 08.12.10
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	(X1)
		Visually inspect for proper formation of each part	PL 08.12.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A. Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.12.10	4	PARTS FORMED TOO THIN. X 8. etc	<u>J</u> asimuz	Scrap and replace. 8 parts bins scrapped. Change to R&D. project 00251A.	<u>Dh</u> 08.12.15	<u>A</u> 08.12.15	<u>/</u> 08.04.12	<u>/</u> 08.12.16

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN (407)

Job Number: 43953

Part Number: D38351

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



BB 08/12/12



Comment: SECOND CHECK

7.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/12/12



8.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 08/12/12

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Pf 08.12.12

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY
NOT FOR
SALES
08.12.12

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.15 Prototype

Job Completion



With deviations
per FAI attached

Nov. 12, 2011

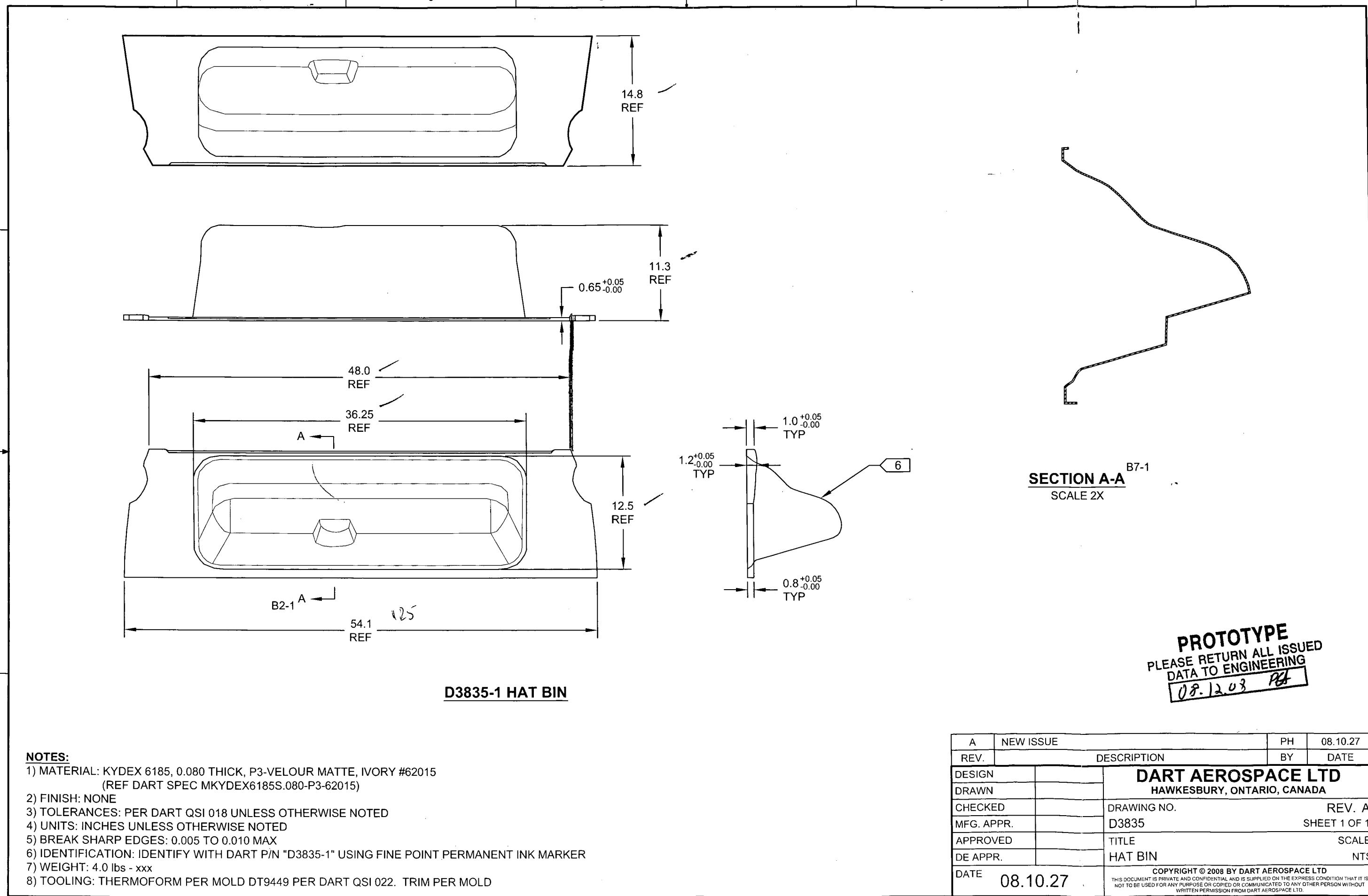
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD

Work Order: 43953

Description: 407 Hat Bin / Prototype

Part Number: D3835-1

Inspection Dwg: D3835 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	N/A			
Shape Definition	/			
Texture Retention	/			
Material imperfections such as bumps, cracks, voids, scratching	/			Thin in the corners ... Also minor bubbles on G.8 flange.

Measured by:

Date: 08-12-12

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.8 (Ref)	+/- 0.100	14.8125	/			
11.3 (Ref)	" "	11.3	/			
0.65	+0.05/-0.0	0.7	/			
12.5 (Ref)	+/- 0.100	12.5	/			
54.1 (Ref)	+/- 0.100	54.125	/			
48.0 (Ref)	+/- 0.100	48.0	/			
36.25(Ref)	+/- 0.030	36.25	/			
1.2	+/- 0.05/-0.0	1.26	x	/		gets trimmed by customer
1.0	+0.05/-0.0	1.8	x	✓		gets trimmed by customer.
0.8	+0.05/-0.0	0.9/0.87	-			"

Measured by:

Date: 08-12-12

Audited by:

Date: 08-12-12

Prototype Approval:

Date: 08-12-12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Receiving Report

Date: 8/10/24Batch No: M109703Supplier: SABICDart P/O: 7280

Packing Slip: Yes No
Invoice: Yes No
Receipt: Cash Cr

Release Note Attached: Yes No N/A
Waybill Attached: Yes No
Shipment Complete: Yes No N/A
QC6 Inspection AS10477 N/A
Work Order N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) L12Admin: Location



SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM #: 1

QUANTITY: 51

51 *8 Oct 08*/27

08/08/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

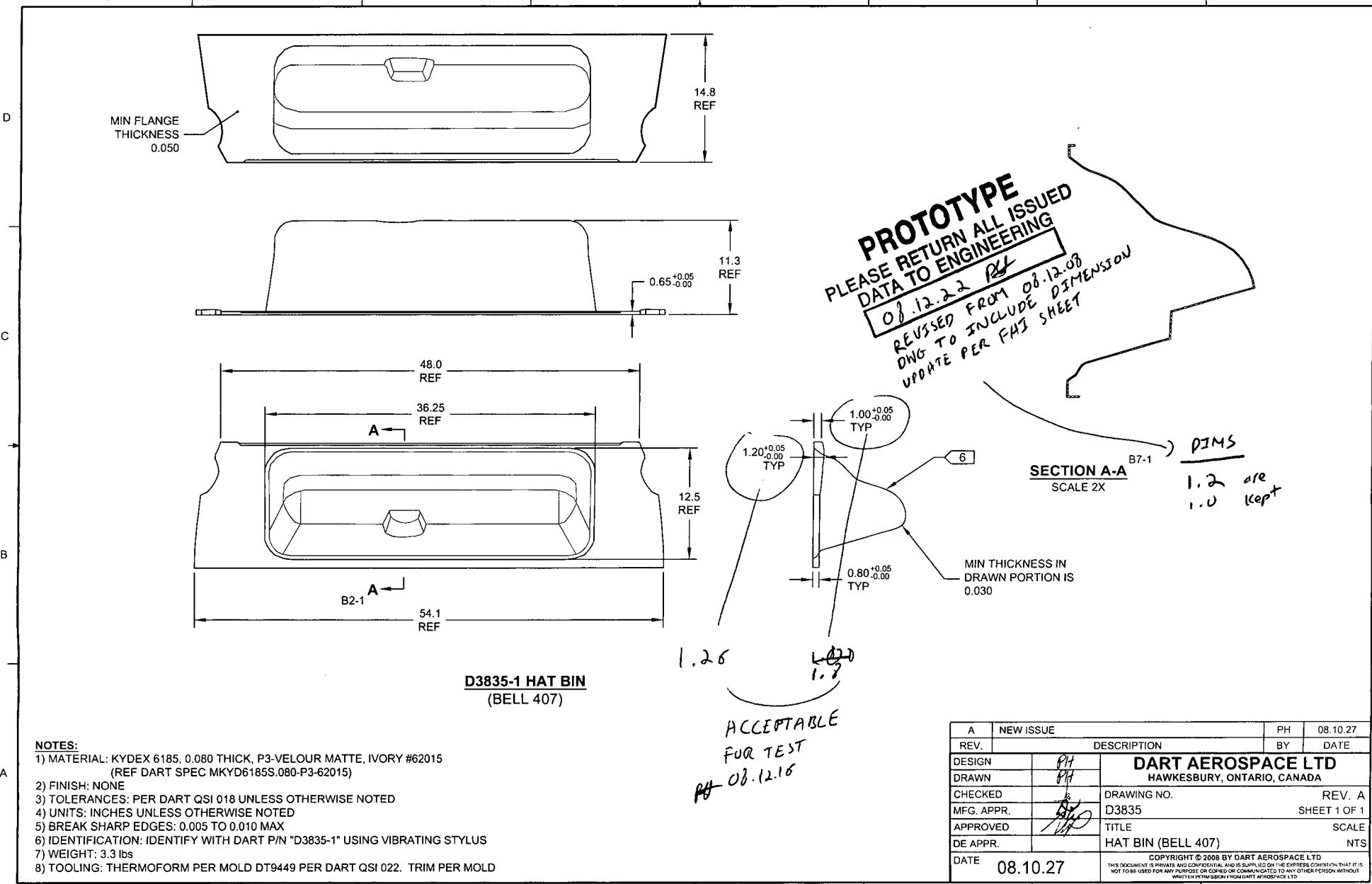
THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS
OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE
PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND
LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

8 7 6 5 4 3 2 1



A	NEW ISSUE	PH	08.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BS	DRAWING NO.	REV. A
MFG. APPR.	BS	D3835	SHEET 1 OF 1
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	HAT BIN (BELL 407)	NTS
DATE	08.10.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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